

Date: Tuesday, 8/21/2007 3:43:47 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	34191		Part Number	D29332UP		
Estimate Number	12931		Drawing Number	D2933 REV C		
P.O. Number	N/A		Project Number	N/A		
This Issue	8/21/2007	S.O. No.	N/A	Drawing Revision	C	
Prsht Rev.	NC	Type	MACHINED PARTS	Material	N/A	
First Issue	N/A			Due Date	9/20/2007	Qty: 10 Um: Each
Previous Run	N/A					
Written By	H					
Checked & Approved By	H 07.08.22					
Comment	Est Rev:A New Issue 07-07-04 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>31386</u> BG 07.09.12 (10)		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr BG 07.09.12 (10)		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET 
Comment: INSPECT ALL DIM TO DIM SHEET BG 07.09.12 (10)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/09/14
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:47 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/0H-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 34191

Part Number: D29332UP

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8.F 07/09/13

(10)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FOL

07/09/13 (10)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

21 07-09-13

(10)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

U 07-09-13

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/09/14

(10)

Job Completion



A 07/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34191
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.123	.123	.123	.123		
C	0.100	0.140		.130	.130	.130	.130		
D	0.210	0.230		.223	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.490	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		3.720.319	3.720.319	3.720.319	3.720.319		
X	1.125	1.145		1.138	1.138	1.138	1.138		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SC</i>	Audited by:	
Date:	07.09.22	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JL</i>

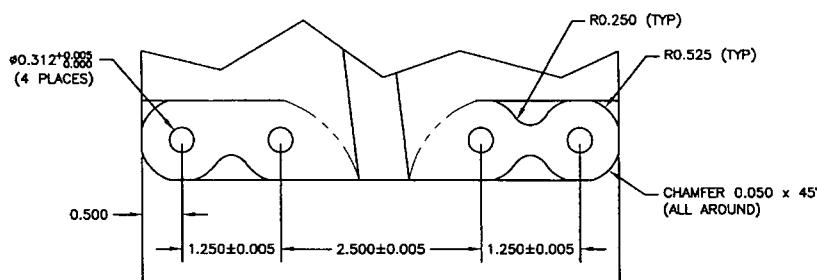
DART AEROSPACE LTD				Work Order:	34191
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.100	0.140		.121	.124	.121	.124		
B	0.100	0.140		.123	.123	.123	.123		
C	0.100	0.140		.130	.130	.130	.130		
D	0.210	0.230		.223	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.125	1.145		1.138	1.138	1.138	1.138		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	07-09-17	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM 	

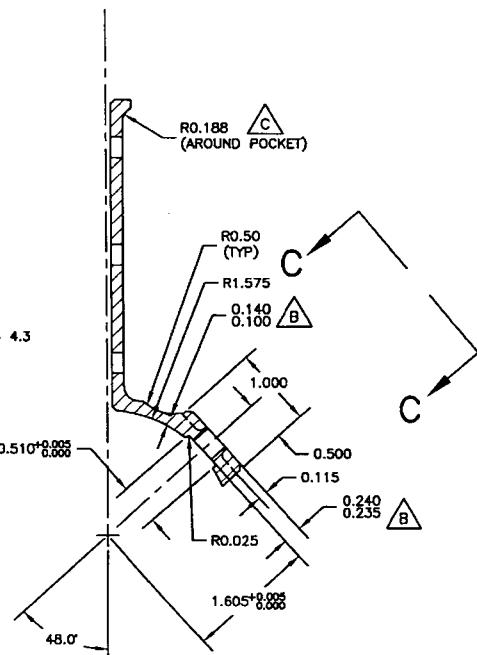


VIEW C-C

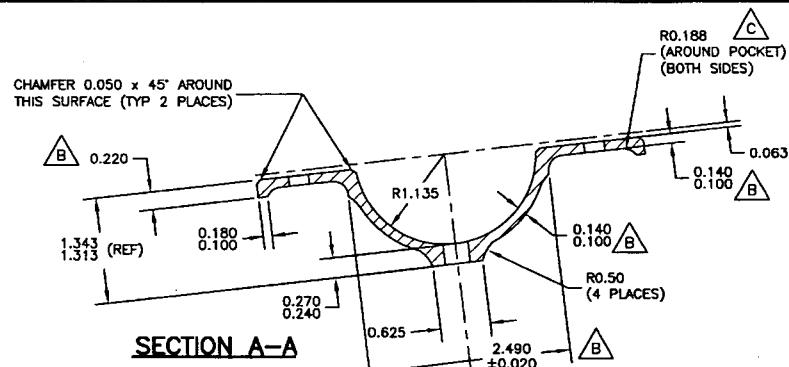
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

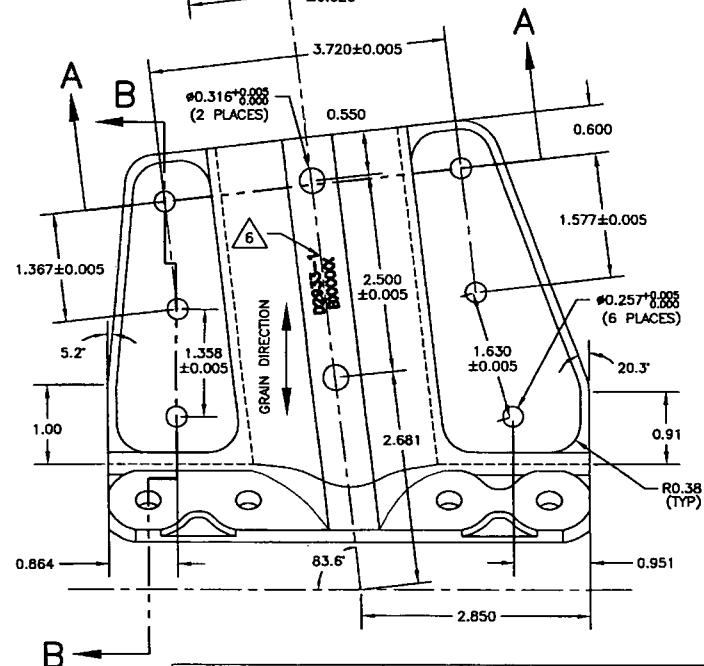
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

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 DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE		SHEET 1 OF 1
06.11.09		SCALE 2:3

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 WITHOUT NOTICE
 WORK ORDER
 NO. 341191
 07.02.12

DART AEROSPACE LTD				Work Order:	34191
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				7/9	2/10	3	4		
A	0.100	0.140		.121	.121				
B	0.100	0.140		.123	.123				
C	0.100	0.140		.130	.130				
D	0.210	0.230		.223	.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.125	.125				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.500	2.500				
S	0.240	0.270		.252	.252				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.319	.319				
X	1.125	1.145		1.138	1.138				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	SG	Audited by:	
Date:	07.09.12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	